

2943

DART AEROSPACE LTD		Work Order:	21305
Description: STA 155 bracket		Part Number:	D2804-2
Dwg: D2804 rev. # A1		Qty:	12 20

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	KJ	04.08.06	20
2	METAL	Cut blanks per template DT8534 Material: 6061-T6 bar 10.00" x 0.50" thick ^{plate} Batch 19601 ^{EC 00.11.07}	ML	04/11/17	12
3	HAAS	Machine as per folio FA103	ML	04/11/17	12
4	QC	Inspect Level 2	ML	04/11/17	12
5	QC	Inspect Level 8	EC	04.11.17	12
6	METAL	Tumble & Deburr	ML	04/11/17	12
7	QC	Inspect Level 5	EN	04/11/17	12
8	FINISHING	Chemical conversion coat per QSI 005	JL	04-12-06	12
9	STORES	Identify and stock	CL	04/12/06	12
10	EXPEDITING	Close W/O Cost / part: 41.68, 59.5 04/12/07 (12) 93.48	KJ	04.12.08	12

Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	JL

RELEASED

EC 00.11.07

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Intial					

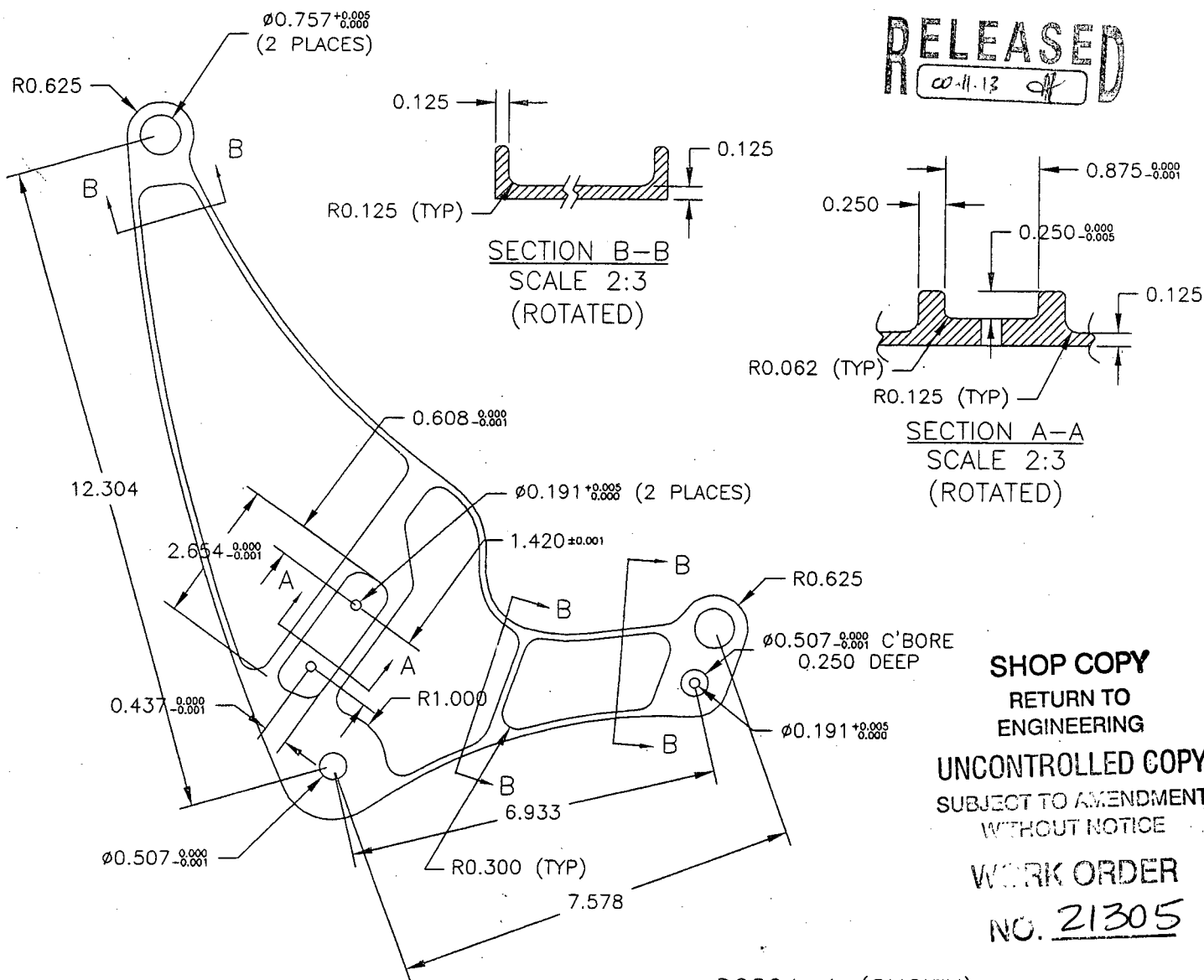
PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. A SHEET 1 OF 2
DATE 00.11.07		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
A1	01.03.14	ADD D2804-043/-044 <i>CP</i>	



RELEASED
00-11-13 *[Signature]*

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 21305

D2804-1 (SHOWN)
D2804-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2804-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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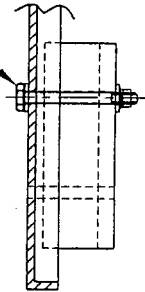
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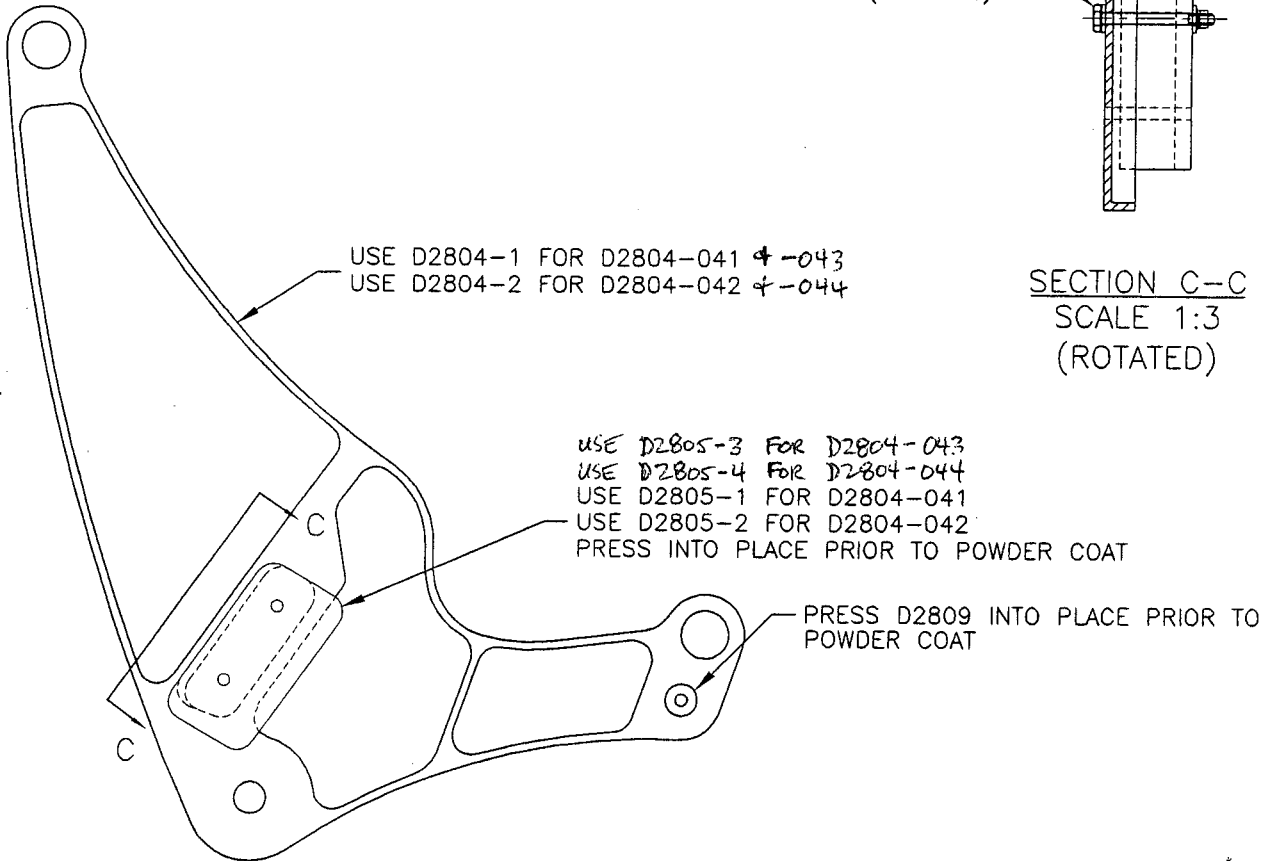
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2804	REV. A SHEET 2 OF 2
DATE 00.11.07	TITLE STA 155 BRACKET		SCALE 1:3

RELEASED
R 00.11.13 #

AN3-16A BOLT (1)
AN960JD10 WASHER (2)
MS21042L3 NUT (1)
(1 PLACE)



SECTION C-C
SCALE 1:3
(ROTATED)



D2804-041 ASSEMBLY (SHOWN) → D2804-043 SIMILAR
D2804-042 ASSEMBLY (OPPOSITE) → D2804-044 SIMILAR



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ENGINEERING

FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY
SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX
(4.3.5.8) PER DART QSI 005 4.3

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WORK ORDER

NO. 21305

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 06, 2004
07:44 am

Work Order No	: 0021305	Department Code:	
Project Name	: D2804-2	Burden Flags	: NNNNNNNN
Project For	: WK439	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2804-2	Invoice Number	:
Description	: STA 155 Bracket	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 20	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 08-05-04		
Est Finish Date	: 09-23-04	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====					
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====					
Burden	: 0.00	0.00	0.00		
=====					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

DART AEROSPACE LTD		Work Order: 21305
Description: STA 155 BRACKET		Part Number: D2804-2
Inspection Dwg: D2804 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	$\pm .010$	0.130	✓		Vern	
0.125	$\pm .010$	0.130	✓		Vern	
RO.125	$\pm .010$	RO.125	✓		R-6	
0.250	$\pm .010$	0.253	✓		Vern	
0.250	$\pm .000$ $\pm .005$	0.250	✓		Vern	
0.875	$\pm .000$ $\pm .001$	0.8745	✓		Vern	
RO.062	$\pm .010$	RO.062	✓		Vern R-6	
Ø0.757	$\pm .005$ $\pm .000$	Ø0.760	✓		Vern	
R.625	$\pm .010$	R.625	✓		Vern	
12.304	$\pm .005$	12.304	✓		Vern	
Ø0.507	$\pm .000$ $\pm .001$	Ø0.507	✓		Vern	
0.437	$\pm .000$ $\pm .001$	0.437	✓		Vern	
0.608	$\pm .000$ $\pm .001$	0.607	✓		Vern	
Ø0.191	$\pm .005$ $\pm .000$	Ø0.192	✓		Vern	
1.420	$\pm .001$ $\pm .001$	1.420	✓		Vern	
0.250 deep	$\pm .010$	0.252	✓		Vern	
6.933	$\pm .005$	6.933	✓		Vern	
7.578	$\pm .005$	7.578	✓		Vern	

Measured by: <i>me</i>	Audited by: <i>PK</i>	Prototype Approval: <i>N/A</i>
Date: 04/11/17	Date: 04.11.17	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	